

Date: Wednesday, 5/31/2006 7:36:20 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BUSHING |
| Job Number : 27285 | |
| Estimate Number : 10517 | |
| P.O. Number : NIA | Part Number : D28061 |
| This Issue : 5/31/2006 S.O. No. : NIA | Drawing Number : D2806 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : NIA Type : MACHINED PARTS | Drawing Revision : A |
| Previous Run : 26565 | Material : NIA |
| Written By : <u>See Comment Below</u> | Due Date : 6/18/2006 Qty: 40 Um: Each |
| Checked & Approved By : <u>06.05.31</u> | |
| Comment : Est:B 05.03.11 Part now turned KJ/JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------|-------------------|
| 1.0 | M6061T6H1000 | 6061-T6 1" HexBar |
|-----|--------------|-------------------|



Comment: Qty.: 0.0962 f(s)/Unit Total: 3.8472 f(s)

M14059 (23")

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar
 (M6061T6H1.000)

Batch: M17030

J.G 06/06/05

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

J.G 06/06/05 42

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/06/05 42

| | | |
|-----|---------------|------------------------------|
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|

**Comment:** CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

J.G 06/06/06 42

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

J.G 06/06/06 42

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/06/14

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:36:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27285

Part Number: D28061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JAN

06:06:10 (42)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SP

06/06/13

(42)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST387

SP

06/06/13

(42)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP

06/06/14

(42)

Job Completion



W 06-06-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

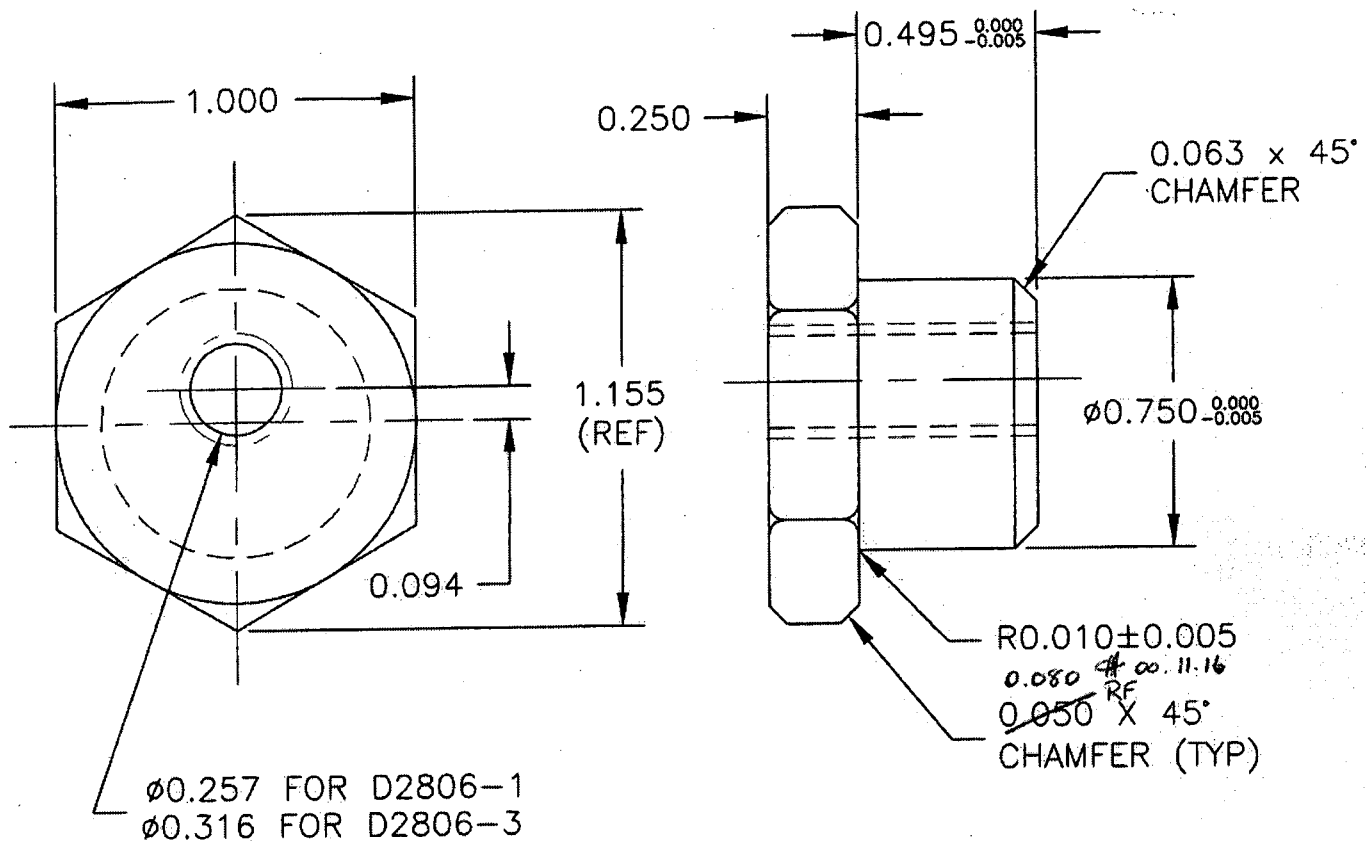
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| | | | |
|------------------|---------------|--|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CP | APPROVED # | DRAWING NO. D2806 | REV. A SHEET 1 OF 1 |
| DATE 00.11.08 | | TITLE BUSHING | SCALE 2:1 |
| A | 00.11.08 | NEW ISSUE | |

RELEASED
00.11.13 #

D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 27285

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